

Work Order ID 61019

Wednesday, August 04, 2010 9:17:15 AM

Page 1

Item ID: 41232-200-001-002

Accept

Setup Start

Revision ID:

Stop

Item Name: Step Actuator RH Ass'y

Start Date: 8/4/2010 Start Qty: 2.00

Cust Item ID:

Required Date: 8/9/2010 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: mf Date: 10-8-04 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
41232-200-001	Rev IR

100	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	1- Assemble as per Dwg 41232-200-001 2-Torque as per Dwg 41232-200-001								

SA 10/08/05 EP 10/08/11

110	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

S 10/08/12 *(72)*

120	Identify as per dwg & Stock Location: <u>364</u>	0.00							
Packaging	Memo	0.00							
Packaging									

10/8/12 *(225)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/08/13
MF
10-8-12

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Picklist Print

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Work Order ID: 61019

Parent Item: 41232-200-001-002

Parent Item Name: Step Actuator RH Ass'y

Start Date: 8/4/2010

Required Date: 8/9/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A New Issue 07-02-28 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
41232-200-002-001 tube		Manufactured	No			100	Each	6.0000	1	2			

Location	Loc Qty	Loc Code
ST364	6	
59814	6	

41232-200-002-003 latch		Manufactured	No			100	Each	14.0000	1	2			
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Location	Loc Qty	Loc Code
ST364	14	
43304	6	
44346	8	

41232-200-002-005 pivot arm		Manufactured	No			100	Each	23.0000	1	2			
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Location	Loc Qty	Loc Code
ST364	23	
43305	15	
44347	8	

41232-200-003-001 Spring (Step Actuator)		Manufactured	No			100	Each	99.0000	1	2			
---------------------------------------------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

Location	Loc Qty	Loc Code
ST365	99	
54173	99	

on picklist r/A
u

2 SB 10/08/05

2 SB 10/08/05

2 SB 10/08/05

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Parent Item: 41232-200-001-002

Parent Item Name: Step Actuator RH Ass'y

Start Date: 8/4/2010

Required Date: 8/9/2010

Start Qty: 2.00

Required Qty: 2.00

41232-200-005-003 Manufactured No

100 Each 6.0000 2 4



Spacer (Step Actuator)

Location

Loc Qty

Loc Code

ST365

6 B 3054

43732

6

AN315-4R Purchased No

100 Each 66.0000 1 2



Nut

Location

Loc Qty

Loc Code

ST324

66

17566

66

AN3-22A Purchased No

100 Each 42.0000 1 2



Bolt

Location

Loc Qty

Loc Code

ST352

42

110998

30

111072

12

AN842-4D Purchased No

100 Each 8.0000 1 2



Elbow

Location

Loc Qty

Loc Code

ST336

8

115299

8

AN960JD10 Purchased No

100 Each 6.0000 2 4



Washer

Location

Loc Qty

Loc Code

ST

6

107715

6

24
B61028 EP 10/08/11
Sh 10/08/05

Sh 10/08/05 ②

Sh 10/08/05 ②

Sh 10/08/05 ②

Sh 10/08/05 ②

M 115107

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item: 41232-200-001-002

Parent Item Name: Step Actuator RH Ass'y

Start Date: 8/4/2010

Required Date: 8/9/2010

Start Qty: 2.00

Required Qty: 2.00

AN960JD416 NAS1149D0463J Purchased No

100 Each 0.0000 2 4



11.15.000



SA 12/08/05 (2)

Washer

D3975-042 Manufactured No

100 Each 7.0000 1 2



Gas Cylinder Assembly, RH

Location

Loc Qty

Loc Code

FG 60410

7 7

100 Each 406.0000 1 2

MS16996-23 Purchased No



cap screw

2 8 10/08/05 (2)

Location

Loc Qty

Loc Code

ST314 103934 112492

406 6 400

100 Each 7.0000 1 2

MS20822-4 Purchased No



elbow

2 8 10/08/05 (2)

Location

Loc Qty

Loc Code

ST299 110363

7 7

100 Each 2,452.000 1 2

MS21042L3 Purchased No



Nut

2 8 10/08/05 (2)

Location

Loc Qty

Loc Code

ST300 114523 114718 114784

2452 115 337 2000

2 8 12/08/05 (2)

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Parent Item Name: Step Actuator RH Ass'y

Start Date: 8/4/2010

Required Date: 8/9/2010

Start Qty: 2.00

Required Qty: 2.00

S-1455 Purchased No 100 Each 154.0000 1 2



spring-step actuator (replaces 71459)

Location

Loc Qty

Loc Code

ST396

154

110154

36

111342

118

2

SS 10/08/05 (2)

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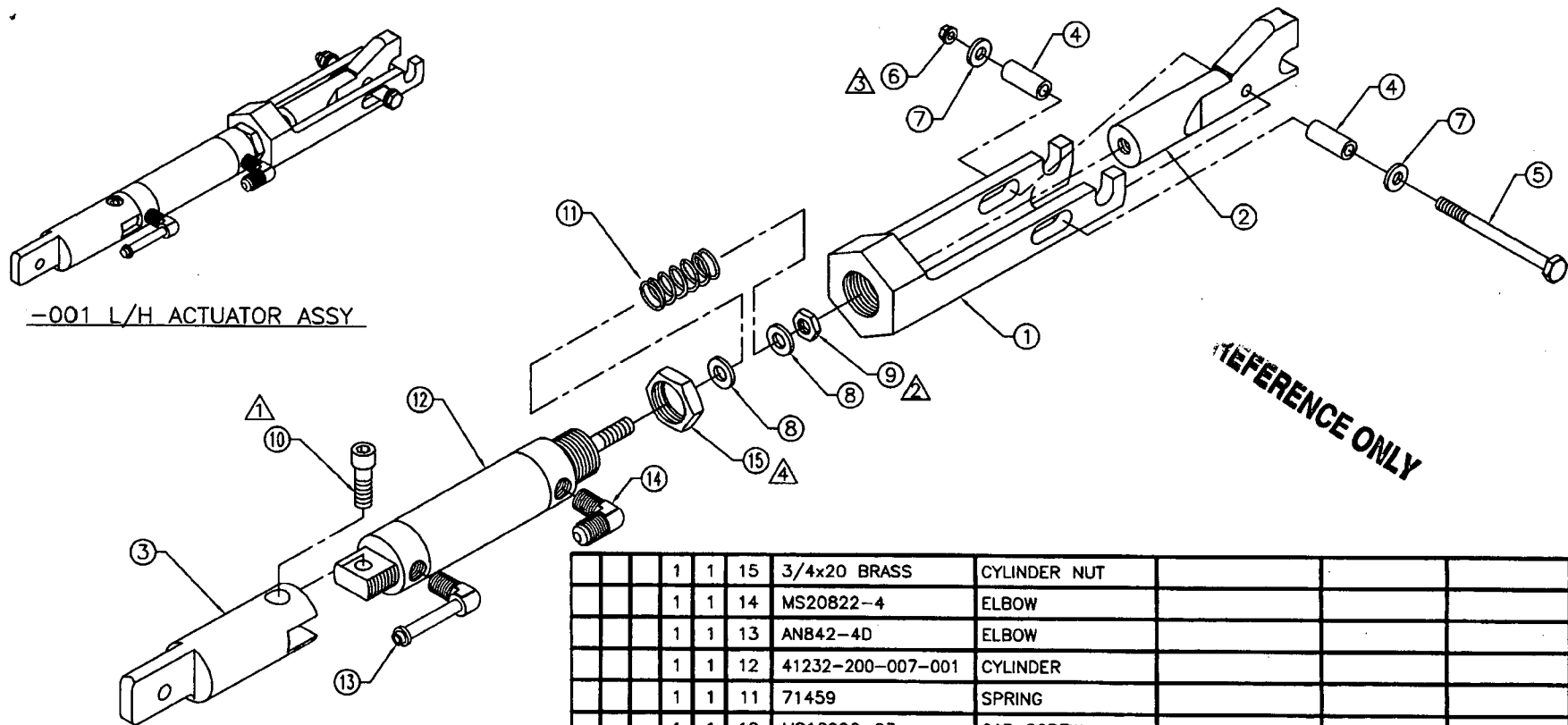
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REFERENCE ONLY

INSTALL ITEM #12
ON OPPOSITE SIDE

-002 R/H ACTUATOR ASSY

- △ TORQUE 80-100 IN.-LB.
- △ TORQUE 20-25 IN.-LB.
- △ TORQUE 50-75 IN.-LB.
- △ TORQUE 50-75 IN.-LB.

NOTES:

NO.	REQ'D PER ASSY	PART NO.	NAME	STOCK SIZE	MATERIAL	MATL SPEC	ZONE
1	1	15	3/4x20 BRASS	CYLINDER NUT			
1	1	14	MS20822-4	ELBOW			
1	1	13	AN842-4D	ELBOW			
1	1	12	41232-200-007-001	CYLINDER			
1	1	11	71459	SPRING			
1	1	10	MS16996-23	CAP SCREW			
1	1	9	AN315-4R	NUT			
2	2	8	AN960JD416	WASHER			
2	2	7	AN960JD10	WASHER			
1	1	6	MS21042-L3	NUT			
1	1	5	AN3-22A	BOLT			
2	2	4	41232-200-005-003	SPACER			
1	1	3	41232-200-002-005	PIVOT ARM			
1	1	2	41232-200-002-003	LATCH			
1	1	1	41232-200-002-001	TUBE			
			-002	R/H ACTUATOR ASSY			
			-001	L/H ACTUATOR ASSY			
			-002-001	END NO.			
LIST OF MATERIAL							
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-002-001	1	41232-000-001	END NO.				
			NEXT ASSEMBLY				

ERA Aviation, Inc.